

Date: Tuesday, 15/04/2008 7:30:10 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)
Job Number	: 38597		
Estimate Number	: 10258		
P.O. Number	:	Part Number	: D2332041
This Issue	: 15/04/2008 S.O. No. :	Drawing Number	: D2332
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	: 37387	Material	:
Written By	:	Due Date	: 22/04/2008
Checked & Approved By	:	Qty:	24 28 Um: Each
Comment	: Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5KJ/ RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4331 f(s)/Unit Total: 10.3950 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

~~M107166~~

M105240

(12)

M107573

(16x)

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total: 2.6208 f(s) 3-276

Material: Ø0.250" 304SS Rod

Batch ~~M105750~~

(12)

M107387

B08/04/28

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

B08/04/28 (30)

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2502 f(s)/Unit Total: 30.0048 f(s)

304 RD Tube .500 x .035W

M107166-248

M106593

(12)

B08/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

Bo8/04/15 (48)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

Bo8/04/28 30x

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

(P/D)

A/R SS Rod Batch: *M107091*

Bo8/04/28 08-04-28 SP

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-29

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Bo8/04/22 (28)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

Bo8/04/30 (28)

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number
1 AN4-4A

Description
Bolt

Batch

M101291 (192)

M106918 (192)

Bo8/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: N/A Fault Category: Prod / FMS - Log NCR: Yes No DQA: S Date: 08/05/01
 QA: N/C Closed: A Date: 08/05/01

NCR: 38597		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/29	# 6	During inspection it was found that 2 arms have a foreign object inside them. R.C. on arms went clean out exact per welding	<i>[Signature]</i> 08/04/29	Ensure that all foreign objects are removed after drilling. Add a comment at the beginning of 6.2 "Ensure to remove all foreign objects" prior to welding. Scrap and Destroy Qty (42) no replace.	<i>[Signature]</i> 08/04/29	<i>[Signature]</i> 08/04/29	<i>[Signature]</i> 08/04/29	<i>[Signature]</i> 08/04/29

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Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M107008

EB08/04/30

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M106051

EB08/04/30

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/30 428

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PK 8/4/30 28

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01 JF

Job Completion



U 08/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

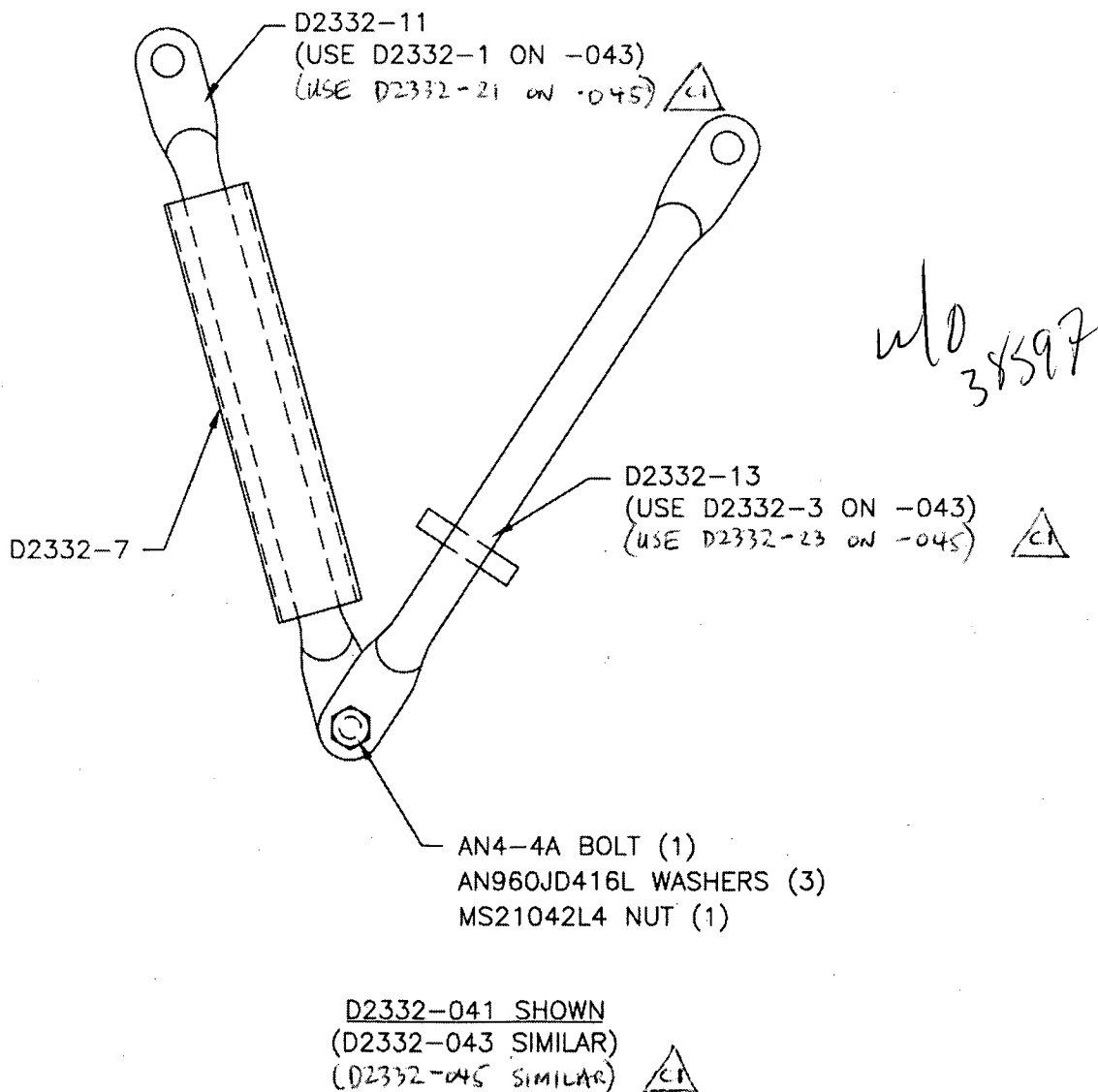
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[initials]</i> 03.08.06	ADD -045 PROP (7.35" LONG)	

RELEASED
03.07.04 *[initials]*



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

REV. C

DESIGN

#

DRAWN BY

#

CHECKED

#

APPROVED

#

DRAWING NO.

D2332

SHEET 2 OF 2

DATE

03.07.03

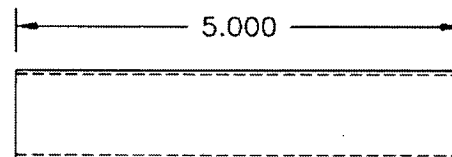
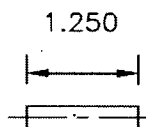
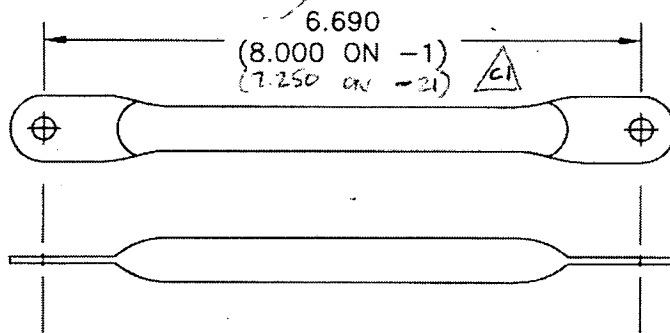
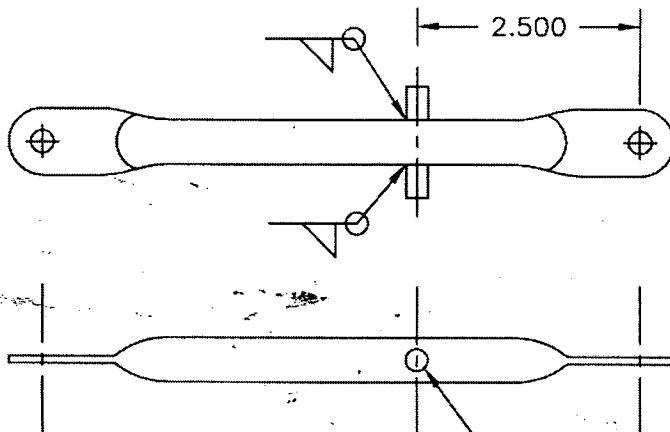
TITLE

LID PROP ASSEMBLY

SCALE

1:2

C	#	03.07.03	MAKE - 041 PROP 6.69" LONG (470)
C1	#	03.08.06	MAKE - 043 PROP 8.00" LONG (101)
			ADD - 045 PROP (7.25" LONG)

D2332-7 LOCKING COLLARD2332-5 STOP PIND2332-11 PROP
(D2332-1 SIMILAR)

DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F: D2332-11 & D2332-5(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

